

Work Order ID 58971

Thursday, May 20, 2010 12:36:57 PM



Page 1

Item ID: D4054-003

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 5/20/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

*K*Date: 10-5-26 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							<i>(6X)</i>
	Small Fab								
Small Fab		0.00							
Small Fab	Memo								
	Bend tube as per Dwg D4054								
	Install sleeves and nuts								
	Flare ends as per Dwg D4054.								
110	QC5- Inspect part completeness to step on W/O	0.00	<i>S. Colletz</i>	<i>27</i>					<i>(X6)</i>
	Memo	0.00							
QC									
Quality Control									

m-f 10/05/26



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod. Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58971

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Page 2

Item ID: D4054-003

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120

Operation
DescriptionIdentify as per dwg & Stock Location: 193Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

Memo

0.00

10-5-27 600 SF

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/01 MF10-5-27

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 20, 2010 12:37:02 PM

Page 1

Work Order ID: 58971



Parent Item: D4054-003



Parent Item Name: Tube Assembly

Start Date: 5/20/2010

Required Date: 5/31/2010

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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AN818-8D	Purchased	No			100	Each	81.0000	2				
----------	-----------	----	--	--	-----	------	---------	---	--	--	--	--

Nut

Location	Loc Qty	Loc Code
ST331	81	
113795	1	
114382	20	
114523	20	
114544	40	

M6061T6T0.500W.049	Purchased	No			100	f	88.9756	1.94				
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6061-T6 RD Tube .500 x.049W

m-h
10/05/26

Location	Loc Qty	Loc Code
MAT	67.3684	
114520	24	
114530	43.3684	
MAT014	21.6072	
111028	16.5895	
111944	5.0177	

MS20819-8D	Purchased	No			100	Each	72.0000	2				
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Sleeve

10/05/26
m-h

Location	Loc Qty	Loc Code
ST323	72	
113795	32	
114445	40	

m-h
10/05/26

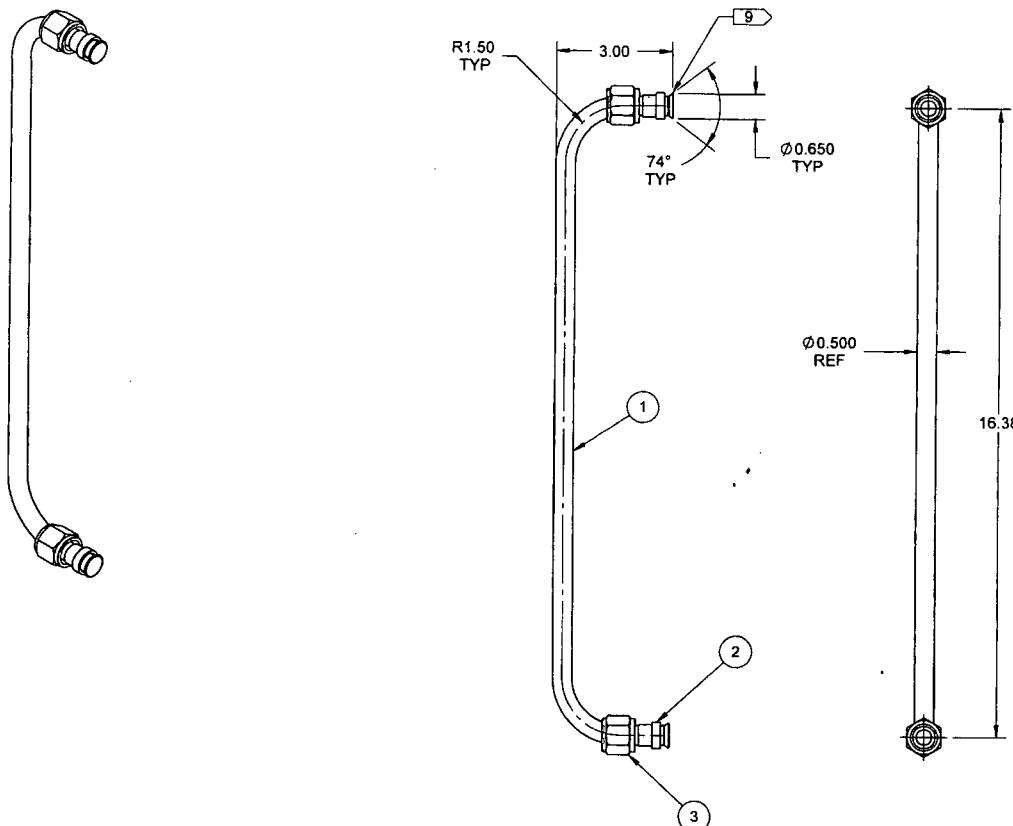
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4054-001 TUBE ASSEMBLY

NOTES:

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-7006
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

A	NEW ISSUE		RF	09.12.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>AB</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>BE</i>	D4054	SHEET 1 OF 3	
APPROVED	<i>140</i>	TITLE	SCALE	
DE APPR.	<i>TH</i>	TUBE ASSEMBLIES		
DATE	09.12.30		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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D4054-001 TUBE ASSEMBLY

NOTES:

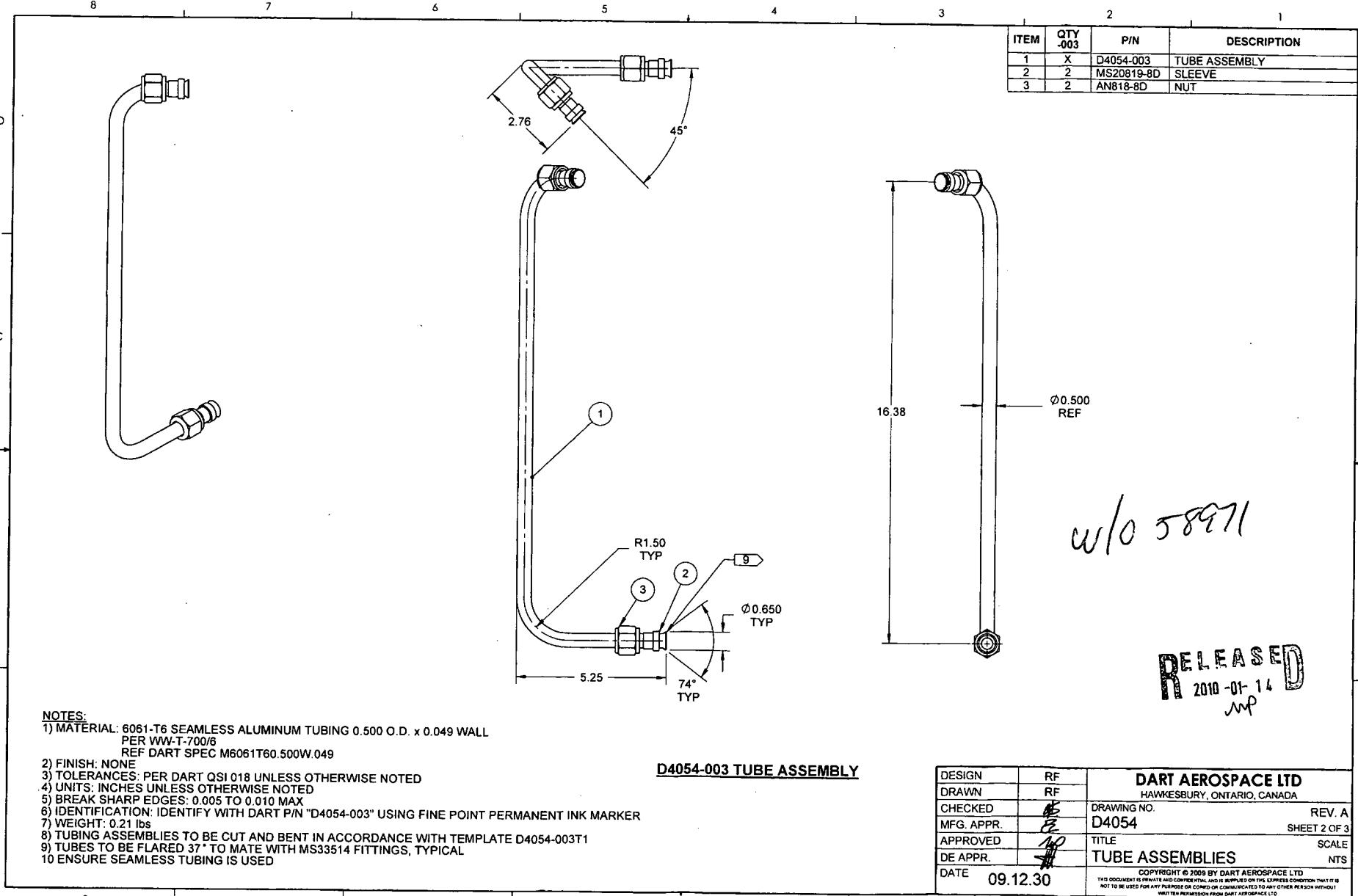
- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL PER WW-T-700/6 REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

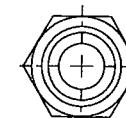
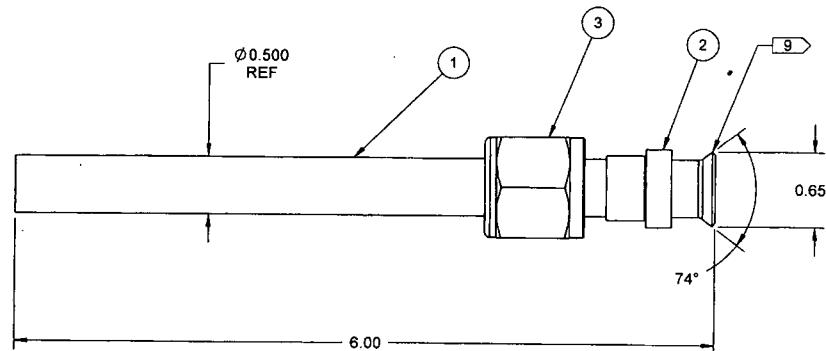
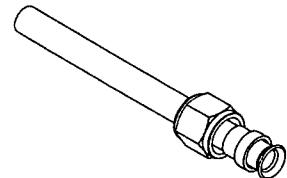
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY .009	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS20819-8D	SLEEVE
3	1	AN818-8D	NUT



D4054-009 TUBE ASSEMBLY

u/o 5897

RELEASED
R 2010-01-14
MP

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	
MFG. APPR.	CB	REV. A	
APPROVED	MP	D4054	
DE APPR.	MP	SHEET 3 OF 3	
DATE	09.12.30	TITLE	
		SCALE	
		NTS	

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